

Work Order ID 55221

January 12, 2010 1:26:33 PM

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Item ID: D4042-043

Accept

Setup Start

Revision ID:

Stop

Item Name: Aft Rib Assembly

Start Date: 1/12/10 Start Qty: 1.00

Cust Item ID:

Required Date: 1/25/10 Req'd Qty: 1.00

Customer:

Reference:

Approvals:

Process Plan:

Date: 10-1-12

Tooling:

Date:

Run Start

QC:

Date:

SPC (Y/N):

Date:

Stop

Sequence ID/
Work Center ID

Operation
Description

Set Up/
Run Hours

Draw
Number

Draw
Rev.

Plan
Code

Accept
Qty

Reject
Qty

Reject
Number

Insp.
Stamp

Draw Nbr

Revision Nbr

D4042

PA3 10/1/12

100

Weld per dwg A/R S.S. rod Batch: 1109213 0.00



Large Fab

Memo

0.00

- 1- Cut as per dwg D4042-3 -
- 2- Drill and chamfer holes as per dwg D4042-3-
- 3-remove identification markings -
- 4- Weld bushing in rib and grind weld flush as per dwg D4043

MATERIAL CERTIFICATION

REQ'D UPON DELIVERY

10-1-12

1001.26 ①

110

QC5- Inspect part completeness to step on W/O

0.00



QC

Memo

0.00

Quality Control

10/1/12

④

PRELIMINARY ISSUE

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			



NOTE: Date & initial all entries




Work Order ID 55221

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Item ID:	D4042-043	Accept		Setup	Start	
Revision ID:					Stop	
Item Name:	Aft Rib Assembly					
Start Date:	1/12/10	Start Qty:	1.00		Cust Item ID:	
Required Date:	1/25/10	Req'd Qty:	1.00		Customer:	
Reference:						

Approvals:	Process Plan:	Date:	Tooling:	Date:	Run	Start	
	QC:	Date:	SPC (Y/N):	Date:		Stop	

Sequence ID/ Work Center ID	Operation Description	Set Up/ Run Hours	Draw Number	Draw Rev.	Plan Code	Accept Qty	Reject Qty	Reject Number	Insp. Stamp
120  QC Quality Control	QC10- Inspect visual per QS1004- ground welds Memo	0.00 0.00		<i>> 8.0612e</i>		<i>(FL)</i>			
130  Packaging Packaging	Identify as per dwg & Stock Location: <i>Basket</i> Memo	0.00 0.00		<i>10 10.01.26</i>	<i>(C)</i>				
140  QC Quality Control	QC21- Final Inspection - Work Order Release Memo	0.00 0.00							

*Prototype
test
10.01.30*

MF 10-1-27

POSITIVE RECALL
EFFECTIVE *10.01.28* AUT *U*
RELEASED _____ DATE _____

W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries

Picklist Print

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Work Order ID: 55221



Parent Item: D4042-043



Parent Item Name: Aft Rib Assembly

Start Date: 1/12/10

Required Date: 1/25/10

Comments: IPP RevA: new issue DD 10.01.07 verified by:EC

Start Qty: 1.00

Required Qty: 1.00

Component Item ID/ Item Name	Replacement Item ID	Mfg/ Purch	Bin Item	Primary Location	Last Location	Route Seq ID	Unit of Measure	Qty on Hand	Remaining Qty To Pick	Qty Issued	Date Issued	Status
D4021-9		Manufactured	No			100	Each	0.0000	2.0000			
Bushing												
M304TS0.750W.049		Purchased	No			100	f	48.4054	2.1491			
304 SQ Tube .75x.75x.049W												

B55545 PD 10.01.26

<u>Warehouse</u>	<u>Loc Qty</u>	<u>Loc Code</u>
<u>Location</u>		
Main Warehouse		
MAT	48.4054	
103240	1.5816	
106604	4.9307	
107460	29.2779	
109087	12.6152	

PD 10.01.26

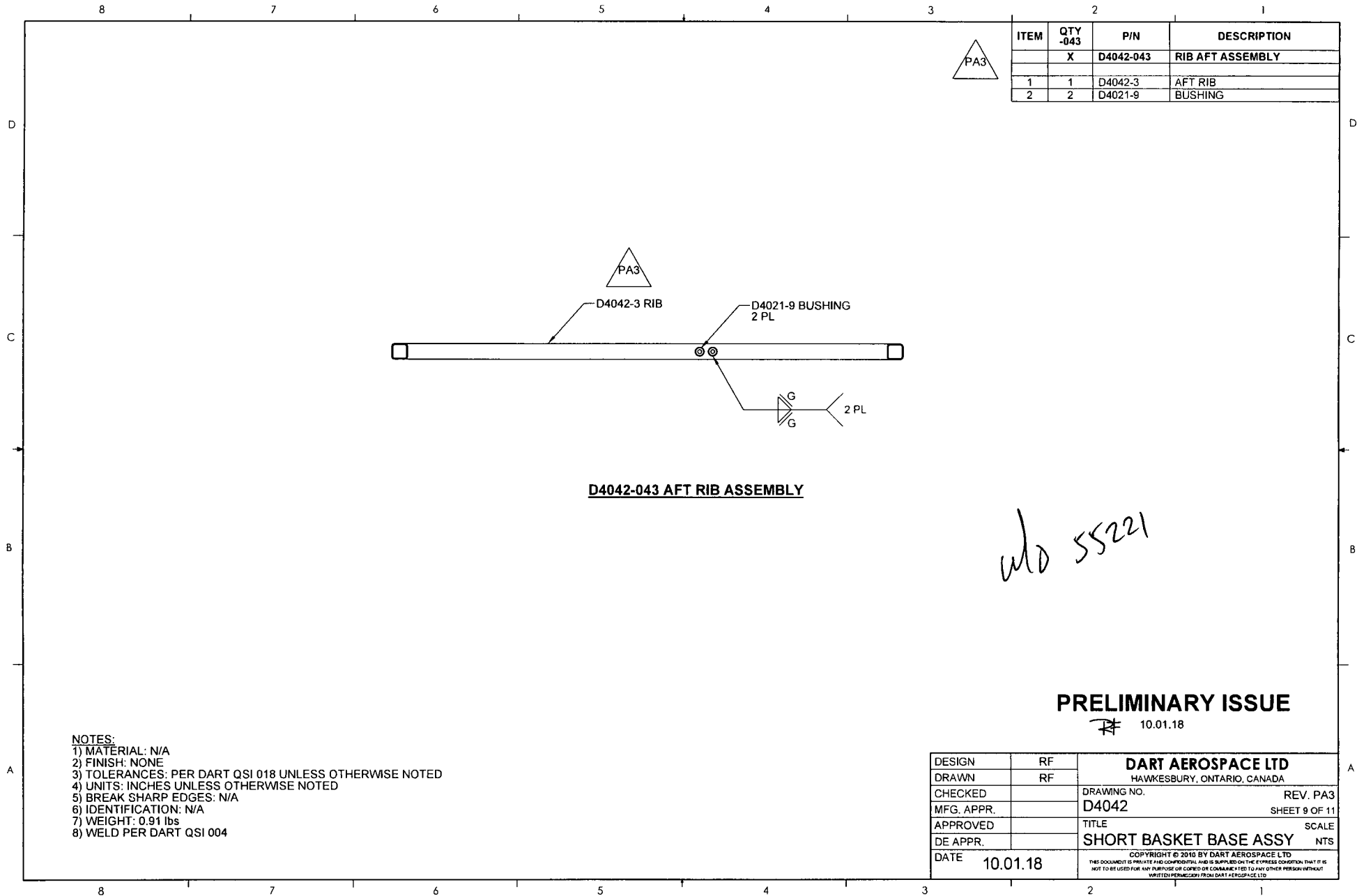
W/O:		WORK ORDER CHANGES					
DATE	STEP	PROCEDURE CHANGE	By	Date	Qty	Approval Chief Eng / Prod Mgr	Approval QC Inspector

Part No: _____ PAR #: _____ Fault Category: _____ NCR: Yes No DQA: _____ Date: _____

Resolution: _____ Disposition: _____ QA: N/C Closed: _____ Date: _____

NCR:		WORK ORDER NON-CONFORMANCE (NCR)						
DATE	STEP	Description of NC Section A	Corrective Action Section B			Verification Section C	Approval Chief Eng	Approval QC Inspector
			Initial Chief Eng	Action Description Chief Eng	Sign & Date			

NOTE: Date & initial all entries



Receiving Report

Date: 8/8/09

Batch No: 17129087

Supplier: MAGNA

Dart P/O: 7019

Packing Slip: Yes ☒ No ☐

Invoice: Yes ☐ No ☒

Receipt: Cash ☐ Cr ☒

Release Note Attached: Yes ☒ No ☐ N/A ☐

Waybill Attached: Yes ☐ No ☒ N/A ☐

Shipment Complete: Yes ☒ No ☐ N/A ☐

QC6 Inspection 4/6/09 ☒ N/A ☒

Work Order ☐ N/A ☒

Discrepancies

Part Number	Description	Quantity Ordered	Quantity Received	Quantity Returned	Quantity Short	Comments

Initials of receiver (if shipment OK) Level 12 [Signature]

Production/Admin:

Date 08/09/02

Received/Costing RC 8763

Initial [Signature]

Location



164382

K6A 1K7

MEME - SAME

140.00
7.00

147.00

Dart Aerospace Ltd

Dart Aerospace Ltd
1270 Aberdeen St
Hawksbury, Ontario K6A 1K7
Phone: (613) 632-3336
Fax: (613) 632-4443

Receiving Slip

Date
Sep 2, 2008

Page
1

Receipt Number
RCP00008763

Purchase From:

Magna Stainless
525 avenue Meloche
Dorval, QC H9P 2W2
Canada

Ship To:

Main Finished Goods Location
Dart Aerospace Ltd
1270 Aberdeen St
Hawksbury, Ontario K6A 1K7

Reference	Description	Contact	Vendor Number	PO Number
			VC-MAG002	PO00007019

Vendor Item Number	Item Number	Description	Qty. Received	UOM	Unit Cost	Extended Cost	Arrival Date
	M304TS0750W049	304 SQ Tube .75x.75x. MATERIAL: AISI 304/316 SS SQUARE TUBING B/N109087	100.0000	f	1.400000	140.00	Sep 02, 2008

Comments:

MAGNA

INDUSTRIAL

MAGNA STAINLESS DIV. DE CSM INC.
525 MELOCHE AVE.
DORVAL, QUEBEC H9P 2W2
(514) 631-1211 FAX: (514) 631-0013

COMMANDE
SALES ORDER

0174394

ADU À /
AD TO:

LIVRÉ À /
SHIP TO:

DART AEROSPACE LTD
270 ABERDEEN STREET
HAWKESBURY
ONTARIO

K6A 1K7

INSTRUCTIONS SPÉCIALES / SPECIAL INSTRUCTIONS

COMMANDE / SALES ORDER		CODE DE CLIENT / CUSTOMER CODE		BON D'ACHAT / BON CLIENT / CUSTOMER ORDER		N° DE TÉLÉPHONE DU CLIENT / CUSTOMER TELEPHONE NUMBER		N° DE TÉLÉCOPIEUR DU CLIENT / CUSTOMER FAX NO.	
0174394		DART		7019		613 632-5200		632-1053	
LIVRÉ VIA / SHIP VIA		CONDITIONS / TERMS		DATE COMMANDE / DATE ORDERED		DATE REQUISE / DATE REQUIRED		DATE LIVRÉE / DATE DELIVERED	
NIR:R-557065-1		NET 30		Aug-26-08		Aug-29-08			
CONTROLE DE QUALITE DU CLIENT / REQUIS / CUSTOMER QUALITY RELEASE REQ'D				CONTROLE DE QUALITE DE MAGNA / REQUIS / MAGNA QUALITY RELEASE REQ'D				PREPAYS / PREPAID	
<input type="checkbox"/>				<input type="checkbox"/>				<input type="checkbox"/>	
N° DE QUALITE / QUALITY NO.		UNITE / UNIT		N° DE COULÉE / HEAT NO.		QTE LIVRÉE / QTY SHIPPED		PRIX PAR / PRICE PER	
A VERIFIER / B/O									
5		pcs		304 180 GRIT 3/4" SQ 18GA X 20"		100/474		5 pcs	
TOTAL :								LBS	

LIBRE DE PAQ.
LIBER OF BOL'S

MTR-AVEC COMMANDE
MTR'S-WITH ORDER

POSTE MAIL ☐ TÉLÉCOPIEUR FAX ☐

PACKING SLIP / BON D'EMBALLAGE

ge: 1
11:28:12

20080826

N° DE COULÉE ÉTAMPER SUR LE CÔTÉ
HEAT NO. STAMP ONE END

MATÉRIEL REÇU EN BON ÉTAT PAR / MATERIAL RECEIVED IN GOOD CONDITIONS BY:

REVISION "E" - 07/07 - FORM 8008



WINNER STAINLESS STEEL TUBE CO.,LTD

ORIGINAL



ADDRESS: 3RD INDUSTRIAL PARK ,XIAOBU VILLAGE, HUASAN TOWN,HUADU DISTRICT, GUANGZHOU, P.R.C.
TEL: +86-20-86847851 FAX: +86-20-86941744

MILL TEST CERTIFICATE

Issued Date:2006/10/12

Customer:

Order No.: 119

Certificate No.: GUL-F684

Article:Stainless steel mechanical structures welded tube						Specification: ASTM A554-03						
Item No.	Size	Length	Qty,Pcs	Net Weight	Type	Heat No.	Annealed Temperature (°F)	Hold Time (minute)	Cooling	Surface Finish	Hydrostatic Test (psi)	ET
6~7#	3/4"SQ×18GA	20'	200	816.86	MT304	TU-YU238460	—	—	—	180Grit	—	—
8#	3/4"SQ×18GA	20'	48	196.05	MT304	TU-YU238460	—	—	—	180Grit	—	—
9~12#	3/4"SQ×16GA	20'	400	2145.80	MT304	TU-YU238951	—	—	—	180Grit	—	—
13#	3/4"SQ×16GA	20'	27	144.84	MT304	TU-YU238951	—	—	—	180Grit	—	—
14#	3/4"SQ×16GA	20'	19	101.93	MT304	TU-YU142400	—	—	—	180Grit	—	—
Chemical Composition (%)									Mechanical Test			
	C	Mn	P	S	Si	Ni	Cr	Mo	T. S. (Ksi)	Y. S.(Ksi)	Elongation(%)	Flattening
MIN						8.00	18.00	—	≥75	≥30	≥35	≤2/3D
MAX	0.080	2.00	0.040	0.030	1.00	11.00	20.00	—				
6~7#	0.025	1.49	0.038	0.004	0.47	8.08	18.14	—	95	51	52	good
8#	0.025	1.49	0.038	0.004	0.47	8.08	18.14	—	95	51	52	good
9~12#	0.026	1.44	0.031	0.005	0.36	8.09	18.29	—	99	49	55	good
13#	0.026	1.44	0.031	0.005	0.36	8.09	18.29	—	99	49	55	good
14#	0.023	1.41	0.035	0.007	0.44	8.09	18.21	—	92	50	51	good
Remarks:						We, Winner Stainless Steel Tube Co., Ltd., hereby certify that the products described herein have been manufactured in accordance with the standards and specifications specified as above and meet the requirements as per order.						
1. Corrosion test: as per ASTM-A262, Practice E :accepted. 2. Dimensions & Visual : good. 3. Materials are free from mercury contamination.						Q. C. Manager/Work Inspector:						

52693/53694/53695

**Purchase Order**

Date Aug 25, 2008	Page 1
Purchase Order Number PO00007019	

Dart Aerospace Ltd
1270 Aberdeen St
Hawksbury, Ontario K6A 1K7
Phone: (613)632-9577
Fax: (613)632-1053

Vendor Address:

Magna Stainless
525 avenue Meloche
Dorval, QC H9P 2W2
Canada
Phone (800) 363-6646
Fax (514) 631-0013

Ship To:

Main Finished Goods Location
Dart Aerospace Ltd
1270 Aberdeen St
Hawksbury, Ontario K6A 1K7

Reference	Contact	Vendor Number VC-MAG002	PO Date Aug 25, 2008	Terms N30	Ship Via yours	Expected Arrival Aug 26, 2008
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Qty. Ordered	Item Number	Description	Expected Arrival	Drop-Ship	Unit Cost	UOM	Extended Price
320.0000	M304S16GA	304/316 Sheet .063 Comments: MATERIAL: AISI 304/316 SS SHEET PER MIL-S-5019 (ANNEALED) 2B FINISH	8/26/2008	No	6.406250	sf	2.050.00
320.0000	M304S22GA	304/316 .032 Sheet Comments: AS ABOVE	8/26/2008	No	3.281250	sf	1.050.00
100.0000	M304TS0750W049	304 SQ Tube .75x.75x.0 Comments: MATERIAL: AISI 304/316 SS SQUARE TUBING	8/26/2008	No	1.400000	f	140.00
80.0000	M6061T6A1000W125	6061T6 ANGLE 1.00 x 1. Comments: MATERIAL: 6061-T6 /T6510/6511 ALUMINUM ANGLE PER AMS-QQ-A-200/8	8/26/2008	No	0.675000	f	54.00
200.0000	M6061T6TS1000W12	6061T6 SQ TUBE 1.00 x 1 Comments: MATERIAL: 6061-T6 OR 6061-T651/T6510/T6511/T62 SQUARE TUBING PER AMS-QQ-A-225/8 OR AMS 4117/4128/4115/4116 OR PER AMS-QQ-A-200/8 OR AMS 4160	8/26/2008	No	1.500000	f	300.00
<div>MATERIAL CERTIFICATION REQ'D UPON DELIVERY</div> <div>M109.57 M 109.057</div>							
Comments:		Tax Summary: GST 179.70 ONT PST 0.00		Less: included tax		0.00	
Entered By: CL CLAVOIE		Subtotal		Total tax		3,594.00	
Approved By:		Total purchase order in		CAD Dollars		179.70	
						3,773.70	